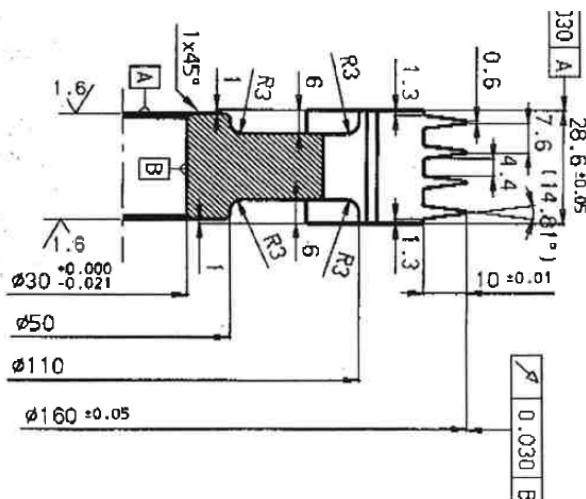


## Fingerjoint Cutter Ø160 Z4

A16-280

Roughing of the profile is done in plunge grinding. Pregrinding and finishing of the profile is ground using standard 14EE1 Profilewheels. Probing is measuring Rakeangle and division if necessary. Fingerjoint cutters can also be ground using 1A1 wheels with coating thickness less than 4.4 mm,



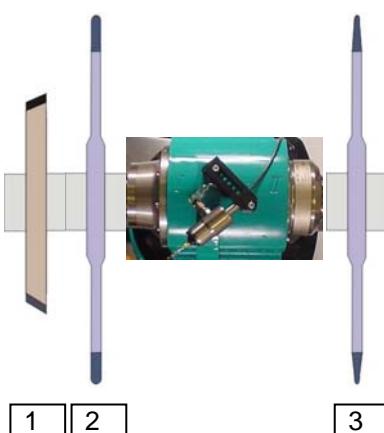
### 1. Cycletime for Production

Workpiece:	Ø 160 mm, Z 4, Length of cutting edge 28.6 mm Material CARBIDE				
Operations	Probe	Flute 1	Prf Rough	Prf Pgnd	Prf fin
Feed [mm/Min]	2000	70	70	70	100
Power [kW]		3	2	1	1
Cutting feed [m/s]		22	20	22	22
Used wheels		1	2	3	3
Grinding time [s]	30	192	1144	192	140
Total cycle time	28 Min 18				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1V1 Ø125 D64
2	14F1 Ø200 D76R1.5
3	14EE1 Ø200 D64



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories:

Responsable engineer: OP. 3.8.10

[www.schneeberger.ch](http://www.schneeberger.ch)

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